

Date: Tuesday, 4/4/2006 1:26:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L /407 STEP ASSY, RH		
Job Number	: 26487A					
Estimate Number	: 11703					
P.O. Number	: N/A			Part Number	: D2724042	
This Issue	: 4/4/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2724 REV C	
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: 25750A			Project Number	: N/A	
Written By	: See Comment Below			Drawing Revision	: C	
Checked & Approved By	: KJ 06.04.04			Material	: N/A	
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM			Due Date	: 4/17/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	D2622120C	Extrusion				
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 3.0000 Each(s)				
Qty	Part #	Description	Batch:			
1	D2622-120C	Extrusion	<u>324563</u>			
Check Material for any Dents or Defects						
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1				
Comment:	LARGE FABRICATION RESOURCE 1					
Cut D2724-2 using D2622 extrusion as per Dwg D2724						
Deburr and bevel ends for welding						
3.0	D2734	206 Step Endplate				
Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)				
206 Step Endplate						
Pick:						
Qty	Part Number	Description	Batch			
2	D2734	End Cap	<u>324402</u>			
4.0	D34581	PLATE				
Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)				
Pick:						
Qty	Part Number	Description	Batch			
2	D3458-1	Plate	<u>325418 = 1</u> <u>326779 = 5</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Action	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:26:33 PM
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Process Sheet

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 26487A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	305417=6

PL 06-04-27

3

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)
A/R AL ROD Batch: m19173 m18838

PL 06-04-28

3/16
3

Grind end cap welds flush

PL 06-04-28

3

7.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PL 06/05/01 (3)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-05-02

3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 06/05/04 (3)

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PL 06-05-04

3

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: m18838

PL 06-05-04

3

PL 06-05-04

3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/05/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number: 26487A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5/9

WELD INSPECTION



JL 060508 (3)



Comment: WELD INSPECTION

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

DL 060508 (3)

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 060508 (3)

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JL 060508 (3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

FL 060508 (3)

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JL 060515 (3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L

N/A JL 060515 (3)

18.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

JL 060515 (3)

Job Completion



u 060515

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

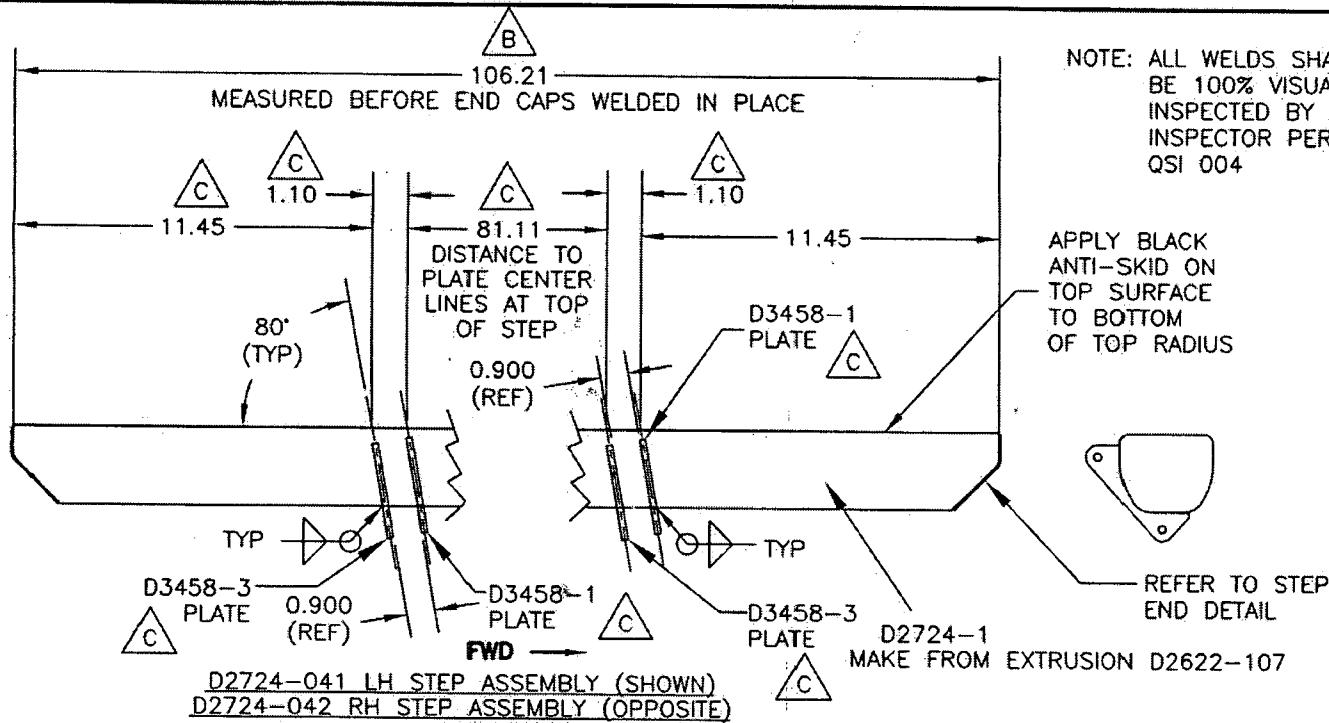
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

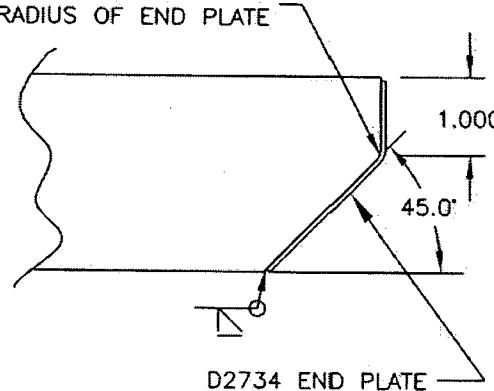
RELEASED
05.11.14



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

B

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
2008 TA

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. C
CHECKED	APPROVED	DRAWING NO. D2724	SHEET 1 OF 1
DATE 05.09.19	97.12.04	TITLE 206L/407 STEP ASSEMBLY	SCALE NIS
A		NEW ISSUE	
B		UPDATED WELD DETAIL REVISED TOLERANCES	
C	98.10.19	RE-DESIGN, ADD D3458-1/-3	
	05.09.19		